



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4382-1

Job Sheet 180962



Part No: D4382-1

Job Qty: 24 ea

Part Name: Angled Bearpaw Clamp



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/18/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D4382 REV.B IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC IPP REV:B 17.12.14 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea		7/31/18	0.00	0.00	Start Up Waterjet		de 18/07/28
100	Waterjet	24 pcs		7/31/18	0.00	1.30	Waterjet1		de 18/07/28
110	QC	24 pcs		7/31/18	0.00	0.00	QC2 Waterjet-3		de 18/07/28
120	QC	24 pcs		7/31/18	0.00	0.00	QC8-4		38
130	Brake NC	24 pcs		7/31/18	0.00	3.09	Brake NC 1		9-89
140	QC	24 pcs		7/31/18	0.00	0.00	QC5		38
150	Packaging	24 pcs		7/31/18	0.00	0.00	Packaging3		9-89
160	QC21-SA	24 Ea		7/31/18	0.00	0.00	QC21		DAS 6

Part Op 100 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary
Descriptions: 120 - QC8- Inspect parts - second check
130 - Form as per dwg DT9709
140 - QC5- Inspect part completeness to step on W/O
150 - Identify as per dwg & Stock Location: _____
160 - QC21- Final Inspection - Work Order Release

NOV 06 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	1.3231 sf (.05513 ea)	90-Start up Operation	5080377

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S14GA	1	109	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Angled Bearpaw Clamp	0.266Inches ± 0.010	0.276 0.256		
2	Angled Bearpaw Clamp	0.370Inches ± 0.030	0.400 0.340		
3	Angled Bearpaw Clamp	0.130Inches ± 0.030	0.160 0.100		
4	Angled Bearpaw Clamp	0.750Inches ± 0.030	0.780		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____		Step #: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA K13 6G2 - 5200 TEL.: 1-800-361-1111 Email: sales@dartaero.com www.dartaerospace.com Date: 07/23/18 Container No: S097191 Part: D4382 - 1 Job No: 180962 Serial No/Batch: S097191 Revision: B Inspector: _____ Exp Date: _____ Instructions: Various STC's																			
Description 		MRB (QSI042) Approval																					
		Completed By																					
		Lead hand / Supervisor Approval Verification																					
				QC / QA Coordinator Approval																			

Root Cause			
Environment ☐	No Re-ver ☐		
Design ☐	Operator ☐		
Doc/Data ☐	Offset/Setu ☐		
Equip/Tooling ☐	Supplier ☐		
Handling/Pre ☐	Training ☐		
Material ☐	Use for Testin ☐		
Internal Transport ☐	Poor Information ☐	☐ Crushing	☐ Inspection Incomplete/Unqualified
Tribal Knowledge ☐	Rushing ☐	☐ Heat Treat	☐ Contamination
LOA ☐	Product Improvement ☐	☐ Wave/Twist in Tube	☐ Countersink
Substation ☐	Process Improvement ☐	☐ Marks/Chatter	☐ Cut Too Short
Past Expiry Date ☐	Manufacturing Process ☐		☐ Instructions Incomplete/Unclear
Misidentified ☐	Past Due ☐		☐ Drill Holes
		OTHER : _____	

			0.720
5	Angled Bearpaw Clamp	0.380Inches $\pm$ 0.030	0.410 0.350
6	Angled Bearpaw Clamp	0.230Inches $\pm$ 0.030	0.260 0.200
7	Angled Bearpaw Clamp	7.940Inches $\pm$ 0.030	7.970 7.910
8	Angled Bearpaw Clamp	0.080Inches $\pm$ 0.010	0.090 0.070

Plex 7/18/18 10:55 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			